



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3674-044
Job Sheet 169364-A



Part No: D3674-044

Job Qty: 1 ea

Part Name: Roller Bracket Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/30/18

Job Tracking No:

Due Date: 1/4/18

Created By: Linda Lacelle

Type: SOLD

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 17-07-29 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	1/3/18	1/3/18	0.00	0.00	Start Up Machining-2		<i>18-01-30</i>
100	Bandsaw	1 pcs	1/3/18	1/3/18	0.00	0.00	Bandsaw1		<i>18-01-30</i>
110	CNC Vertical Machining	1 pcs	1/3/18	1/3/18	0.06	3.70	HAAS 5 Axis		<i>18-01-30</i>
120	QC	1 pcs	1/3/18	1/3/18	0.00	0.00	QC2 Machining-2		<i>18-01-30</i>
130	QC	1 pcs	1/3/18	1/3/18	0.00	0.00	QC8 Machining-2		<i>18-01-30</i>
140	Small Fab	1 pcs	1/4/18	1/4/18	0.00	0.08	Small Fab-4		<i>18-01-30</i>
150	QC	1 pcs	1/4/18	1/4/18	0.00	0.00	QC5		<i>38</i>
160	Packaging	1 pcs	1/4/18	1/4/18	0.00	0.00	Packaging3-1		<i>38</i>
170	QC21-SA	1 Ea	1/4/18	1/4/18	0.00	0.00	QC21		<i>38</i>

Part Op 100 - Cut blanks: (1.500" x 2.250") 5.600" long
Descriptions: 110 - 1-Machine D3674-3 as per Folio Fb486 and Dwg D3674-3.
140 - Assemble D3674-043 as per Dwg D3674.

6
JAN 30 2018 *9-00*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-B1.500X02.250	17-4 SS Bar 1.50 X2.250	.4660 ft (.466 ea)	90-Start up Operation	
D3121-21	Bolt	2 Ea (2 ea)	140-Small Fab	
D3183-045	Bearing Assembly	2 Ea (2 ea)	140-Small Fab	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M17-4-B1.500X02.250	0	15	0
140-Small Fab	D3121-21 <i>F150569</i>	2	7	0
	D3183-045 <i>F165745</i>	2	23	0

Part Specifications

Specifications could not be found.

DART
AEROSPACE
S036822

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Roller Bracket Assembly

PART NO: D3674-044
Original Serial #: S036806

Revision:

Operation:

Change No:

Start up Operation

01/30/18

Job No: 169364-A

JART AEROSPACE LTD		Work Order: 1169 364-A
Description: Roller Bracket Assembly		Part Number: D3674-044
Inspection Dwg: D3674	Rev: B	Page 1 of 2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.10	+/-0.030	.100	✓		SLIO	Vern
5.323	+/-0.010	5.323	✓		Height gauge	
5.036	+/-0.010	5.037	✓		"	
2.49	+/-0.030	2.846	✓		"	
2.385	+/-0.010	2.385	✓		"	
1.555	+/-0.010	1.552	✓		SLIO	Vern
0.265	+/-0.010	.263	✓		"	
13°	+/-0.5°	13°	✓		Protractor	
R0.25	+/-0.030	.250	✓		Rad gauge	
0.398	+/-0.010	.398	✓		SLIO	Vern
0.795	+/-0.010	.795	✓		"	
11°	+/-0.5°	11°	✓		Protractor	
Ø0.201 x 0.100 DP	+0.005/-0.001 x +/-0.010	.201 X 100°	✓		SLIO	Vern
3.954	+/-0.010	3.955	✓		"	
R0.29	+/-0.030	.290	✓		Rad gauge	
Ø0.392	+0.002/-0.000	.3935	✓		SL02 Mic	
R0.13	+/-0.030	.130	✓		Rad gauge	
R0.25	+/-0.030	.250	✓		"	
R0.19	+/-0.030	.190	✓		"	
0.162	+/-0.010	.163	✓		SLIO	Vern
0.995	+/-0.010	.996	✓		↓	
4.26	+/-0.030	4.260	✓			
0.162	+/-0.010	.164	✓		Rad gauge	
R0.19	+/-0.030	.190	✓		"	
R0.25	+/-0.030	.250	✓		SLIO	Vern
0.36	+/-0.030	.360	✓		↓	
2.08	+/-0.030	2.080	✓			
1.16	+/-0.030	1.160	✓		↓	
1.89	+/-0.030	1.890	✓			
R0.19	+/-0.030	.190	✓		Rad gauge	
0.020 x 30°	+/-0.010 x +/-0.5°	.020 X 30°	✓		SLIO	
0.182	+/-0.010	.182	✓		"	
0.170	+/-0.010	.172	✓		"	
4.8°	+/-0.5°	4.8°	✓		Protractor	
0.741	+/-0.010	.736	✓		SLIO	
0.07 x 45°	+/-0.030 x +/-0.5°	.070 X 45°	✓		"	
R0.06	+/-0.030	.060	✓		Rad gauge	
60°	+/-0.5°	60°	✓		Protractor	
0.032	+/-0.010	.031	✓		SLIO	

DART AEROSPACE LTD		Work Order:	
Description: Roller Bracket Assembly		Part Number:	D3674-044
Inspection Dwg: D3674	Rev: B	Page 2 of 2	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	+/-0.010	.050	✓		SLIO	Ver N
0.200	+/-0.010	.203	✓			
0.235	+/-0.010	.235	✓			
100°	+/-0.5°	100°	✓		Protractor	
0.080	+/-0.010	.083	✓		SLIO	Ver N

Measured by:	<i>[Signature]</i>	Checked by:	<i>[Signature]</i>	QC Inspector:	
Date:	18-01-29	Date:	18-1-30	Date:	

Engineering Approval: (If necessary)		Date:	
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Rev	Date	Change	Revised by	Approved
A	16.08.30	New Issue	KJ <i>[Signature]</i>	<i>[Signature]</i>